



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18419-5
Job Sheet 178762



DL-SM27

4218
SMP
7-11

Part No: RBT18419-5

Job Qty: 6 ea

Part Name: Mooring Adapter (Female)



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/7/18

Job Tracking No:

Due Date: 7/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18419 Rev.A IPP Rev. A 18.06.07 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/4/18	7/4/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	6 pcs	7/4/18	7/4/18	0.00	3.00	MORI SL-154		
120	QC	6 pcs	7/4/18	7/4/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs	7/4/18	7/4/18	0.00	0.00	QC8 Machining-4		
140	Packaging	6 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3-1		
150	QC21-SA	6 Ea	7/4/18	7/4/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FC136 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG. ***See engineering for sign off, Reference RBT18409 for location***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.500	304 Round Bar 1.500	1.5000 ft (.25 ea)	90-Start up Operation	M135559-1:1.93

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.500	2	8	0

Part Specifications

Specifications could not be found.

Plex 7/4/18 9:34 AM dart.logan.david



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S091430



Part: RBT18419-5

Job No: 178762

Serial No/Batch: S091430

Revision: A

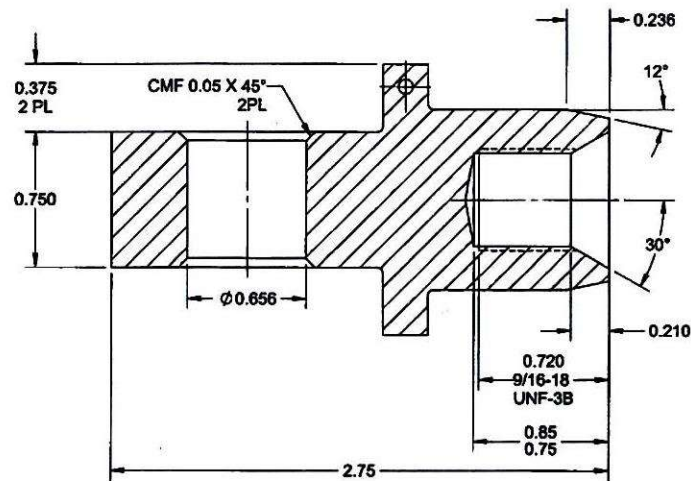
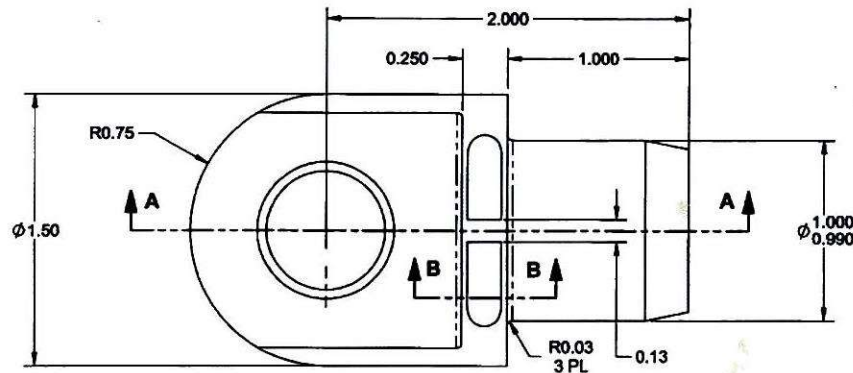
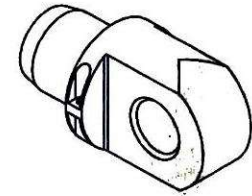
Inspector:

Exp Date:

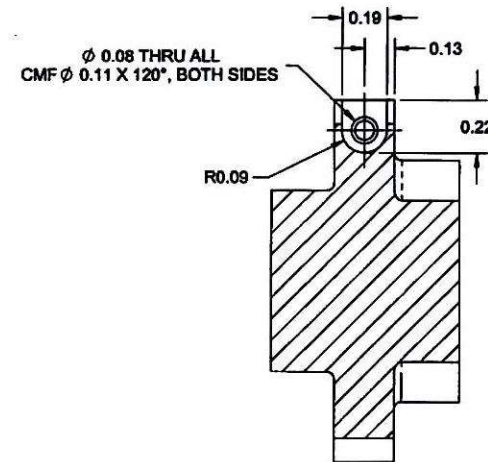
Instructions:

Date: 07/12/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **178762**
20180704



SECTION A-A



SECTION B-B

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: 0.005" TO 0.010"

- 7) IDENTIFICATION: N/A

RBT18419-5 MOORING ADAPTER (FEMALE)

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 03/02/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 03/08/2018	TOOL PART #	REV. A
MFG. APPR.	DP 03/08/2018	RBT18419	SHEET 5 OF 8
APPROVED	ML 03/08/2018	TITLE	SCALE
DATE 6/4/2018		AIRCRAFT MOORING ADAPTER KIT	NTS
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DART AEROSPACE LTD		Work Order: 178762
Description: Mooring adapter (female)		Part Number:
Inspection Dwg: RBT 18419	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.50	±.01	1.495	✓		Vern LPOB	
R.75	±.01	.750	✓		↓	
2.000	±.005	1.9985	✓		H.G.	
.250	±.005	.250	✓		Vern LPOB	
1.000	±.005	1.000	✓		↓	
0.995	±.005	.995	✓		↓	
.13	±.01		✓		↓	
R.03	±.01	.032	✓		↓	
.375	±.005	.3705	✓		H.G.	
.750	±.005	.748	✓		Vern LPOB	
.05 x 45°	±.01 x 1°	.045 x 45°	✓		↓	
Ø.656	±.005	.659	✓		↓	
2.75	±.01	2.746	✓		↓	
.80	±.05	.842	✓		↓	
.720	±.005	.725	✓		↓	
9/16-18 UNF-3B	GD-ND GD	GD	✓		↓	
30°	±1°	30°	✓		↓	
12°	±1°	12°	✓		OPT Comp	
.210	±.005	.210	✓		Vern LPOB	
.236	±.005	.238	✓		OPT Comp	
Ø.08	±.01	Ø.080	✓			
Ø.11 x 120°	±.01 x 1°	.105 x 120°	✓			
.19	±.01	.186	✓			
.13	±.01	.130	✓			
.22	±.01	.215	✓			
R.09	±.01	R.09	✓			

Measured by: P	Checked by: [Signature]	QC Inspector:
Date: 18-07-	Date: 18/07/13	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					